

Date: Tuesday, 26/09/2006 10:20:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 28640
 Estimate Number : 11143
 P.O. Number : *N/A* Part Number : D32073
 This Issue : 26/09/2006 S.O. No. : *N/A* Drawing Number : D3207 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 28640 Material : *N/A*
 Due Date : 03/10/2006 Qty: 8 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est A : 04.06.09 New issue KJ/RF
 Est Rev:B Now on Waterjet 06-09-26 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1603 sf(s)/Unit Total: 1.2827 sf(s)

6061-T6 .125 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.125" thick
 (M6061T6S.125)

Identify for D3207-3

Batch: *m101092*

m1 06 09 09

m1 06 09 27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3207

Dwg Rev: *A*

Prog Rev: *A*

m1 06 11 09 (8) (8)

m1 06 09 27

2-Deburr if necessary

SAG

06.10.02
06.04.

SAG 06.11.23 (8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m1 06 11 09 (8)

m1 06 09 27

(8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Job 04-28

(8)

11/06/10 (8)

Date: Tuesday, 26/09/2006 10:20:37 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28640

Part Number: D32073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3207

SB 06/11/30 (9)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/30 (9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL 06/12/02 X9

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

06/12/02 X9

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/12/05 (9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57415

06/12/05

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08 (9)

Job Completion



CL06/12/08

| | |
|-------------------------------------|-----------------------------|
| DART AEROSPACE LTD | Work Order: 28640 |
| Description: Bracket | Part Number: D3207-3 |
| Inspection Dwg: D3207 Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

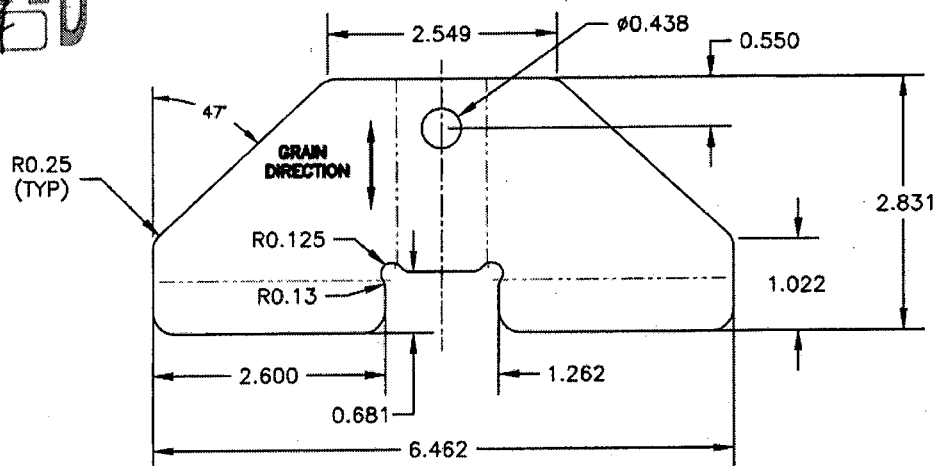
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|--------------|----------|-------------|-------------|---------------------|-------------|
| Measured by: | mal ml | Audited by: | [Signature] | Prototype Approval: | [Signature] |
| Date: | 06/11/09 | Date: | 06/11/10 | Date: | [Signature] |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

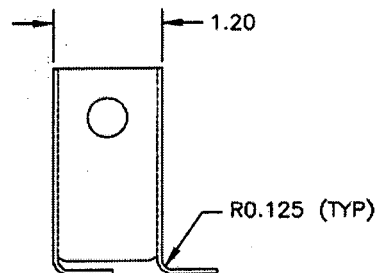
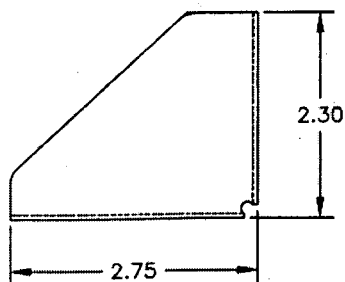
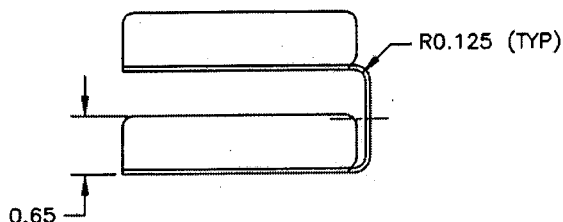


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| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3207 | REV. A SHEET 1 OF 3 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN



D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 28640

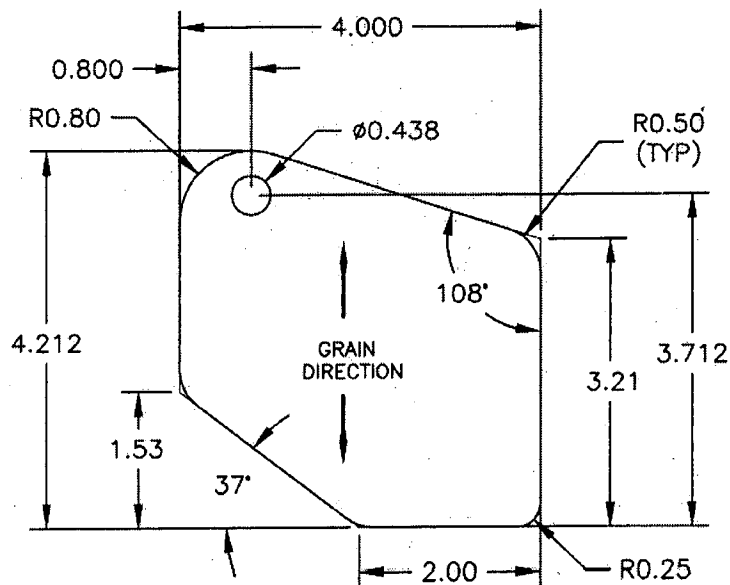
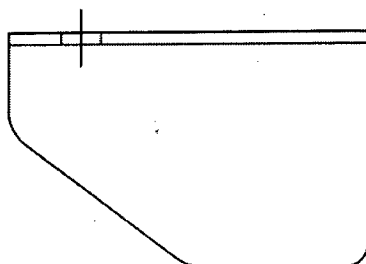
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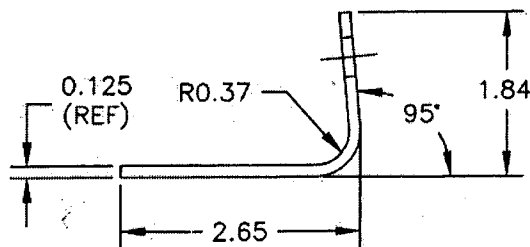
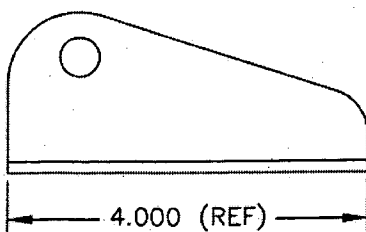


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|------------------------|-------------------------|---|------------------------|
| DESIGN [Signature] | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3207 | REV. A SHEET 2 OF 3 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
04.01.05 [Signature]



D3207-3 FLAT PATTERN



D3207-3 BEND DETAIL

D3207-3 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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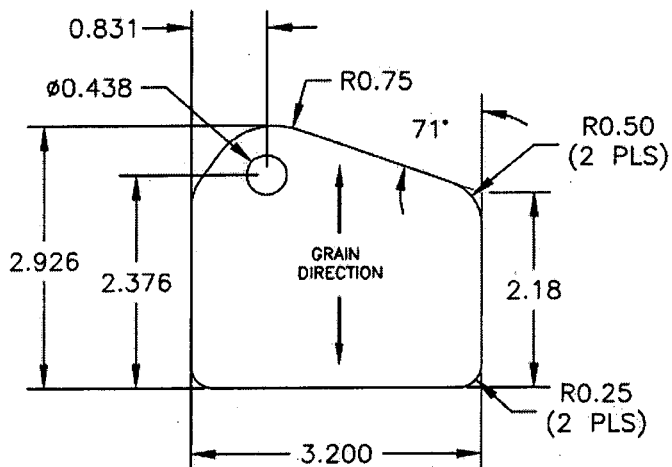
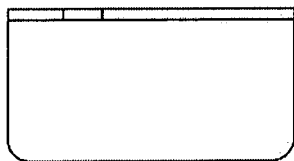
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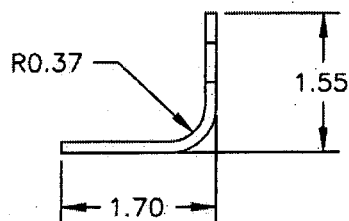
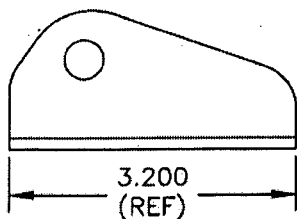


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| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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